Date: User: Tuesday, 05/08/2008 7:57:01 AM

Jean-Luc Menard

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: BUSHING

Job Number Estimate Number : 40986

P.O. Number

: 10175

: 05/08/2008 S.O. No. : **Part Number** 

: D2570

This Issue

: NC

**Drawing Number** 

- D2570 REV B

Prsht Rev. First Issue

: 11

: MACHINED PARTS Type

Project Number **Drawing Revision**  : N/A

Previous Run

: 40197

; B

Material **Due Date** 

: 12/08/2008

Each

Written By

Checked & Approved By Comment

Re-format, Removed finishing; Material change K : Est E 02.08.29

est F 07.07.06

rev B dwg

EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M303R0750

303 Round Bar 0.750

0.0810 f(s)/Unit

8.0955 f(s)

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Total:

Batch MIOSJ2(1)

2.0

HARDINGE

Comment: Qty.:



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburt

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



SECOND CHECK



4.0

QC8

5.0

Comment: SECOND CHECK **PACKAGING 1** 

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Page 1

Form: rprocess

Tuesday, 05/08/2008 7:57:01 AM Date: User: Jean-Luc Menard

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: BUSHING** 

Job Number: 40986

Part Number: D2570

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

FINAL INSPECTIONWIO RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DESIG	DESIGN DRAWN BY PH PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	ŒD	APPROVED	DRAWING NO.	REV. B		
	献	91	D2570	SHEET 1 OF 1		
DATE			TITLE	SCALE		
07.0	04.17		BUSHING	1:1		
Α		96.09.16	NEW ISSUE			
В		07.04.17	UPDATE NOTES			

- 0.800±0.010 0.060±0.005 -0.030 X 20° R0.010 (REF)

w/0 409 86 Ø0.750 Ø0.257<sup>+0.005</sup><sub>-0.000</sub> Ø0.425<sup>+0.000</sup><sub>-0.002</sub>

## D2570 BUSHING

## D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- ALL DIMENSIONS ARE INCHES 3)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	40986
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	798"				
0.060	+/-0.005	,060"				
R0.010	+0.010/-0.000	Pi,0/0"				
Ø0.425	+0.000/-0.002	\$ 424"		Í		
Ø0.257	+0.006/-0.001	\$ 259"				
Ø0.750	+/-0.010	0 744"				
0.030 x 20°	+/-0.010	(035°×20	, to			
					ļ <b></b>	
·····						

Measured by: J.F.	Audited by:	H. A/And	Prototype Approval:	N/A
Date: 08/08/06	Date:	08/08/08	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	ĶJ/RF	
	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C		Dimensions updated per Dwg Rev. B	KJ/JLM IA	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD 9	170